

Work Order ID 137433

Wednesday, September 30, 2015 12:49:32 P

137433

Page 1

Item ID: D206-605-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Rear Locker Extender

Stop

NS2

Start Date: 9/30/15 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/09/15 Req'd Qty: 4.00

4 3

Customer:

Reference: REWORK (REPAINT)

Approvals: Process Plan:

Date: 10-9-30 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4678

A

ML 15-25-10-25

105

0.00

105

0.00

QC

Quality Control

Memo

PULL FROM STOCK

D206-605-043 X4

BATCH:

100228

100229

100230

100231

TO BE REWORKED

10-3-15-9-30

AV 526C 83218
M128052
ST 240
NAS1492W816A
M129764
ST 327

PATENT N/A		CHG CHG001	
P/N	D206-605-043	SIC	SH01-61
DESC.	Rear Locker-Extender-	SIC	SR01420NY
LOT	B100228	SIC	
MODEL	Bell 206A/B/L/L1/L3/L4	SIC	
TC APPROVAL #09-09		MADE IN CANADA	

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Page 2

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Run

Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

110

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 29950

Supplier: FDC.

***EXTREME CARE MUST BE TAKEN TO PROTECT THE SURFACES OF
THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE
FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR
DENTS.***

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

115

115

Outsource7

Memo

0.00

0.00

Outsource rework

REWORK AS PER QUOTE 1278
REPAINT FINISH + TOOLING

15-10-23

P.T.O.

Work Order ID 137433

137433

Page 3

Wednesday, September 30, 2015 12:49:32 P

Item ID: D206-605-043

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Customer:

Reference: REWORK (REPAINT)

Run Start

NR1

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125	QC3- Inspect Part Finish	0.00				3			DAS 38 9-89
125									OCT 23 2015
QC	Memo	0.00							
Quality Control									
150	Packaging	0.00				3X			DAS 28 9-89
150									OCT 23 2015
Packaging	Memo	0.00							
Packaging	REPACKAGE USING NEW BATCH NUMBER								
160	QC21- Final Inspection - Work Order Release	0.00							
160									OCT 23 2015
QC	Memo	0.00							
Quality Control									

ML3 OCT 23 2015

Picklist Print

Wednesday, September 30, 2015 12:49:38 PM

Page 1

Work Order ID: 137433

137433

Parent Item: D206-605-043

D206-605-043

Parent Item Name: Rear Locker Extender

Start Date: 9/30/15

Required Date: 10/09/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.04.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D206-605-043

Manufactured No

Each 0.0000

D206-605-043

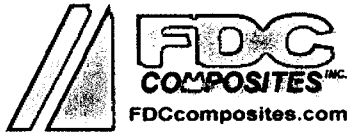
Rear Locker Extender

**

4

15-9-30

B: 100228
229
230
231



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CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: 29950

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Vendor Part Number</u>	<u>Description</u>	<u>Lot</u>
1	3	D407-605-045	137432	Rear Locker Extender	B100220 B100221 B100222
2	3	D206-605-043	137433	Rear Locker Extender	B100228 B100229 B100230

NOTE :

Operation performed : interior surface re-painting as specified on Darts's PO by sanding gelcoat to remove cracks and application of PPG 6941241A 2C Acrycote White paint Lot 00022.
Catalyst was PPG 794002 2C Acrycote Lot 98841.

Catalysed PPG acrycote paint complies with FAR 25.853 Appendix F Part I (b)-Par.4 (Vertical Test 60 seconds). See attached Analysis Report from CTT Group.

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature: _____

Jules Fournier, BDI, Quality Manager

Date: _____

2015-10-15

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tél. : 450 357-1344

Bon de livraison

15/10/2015

Commande : 2257
Référence : PO #29950/1/2

Client : Dart

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Expédier à

Même

Tél.: 1 613 632-9577

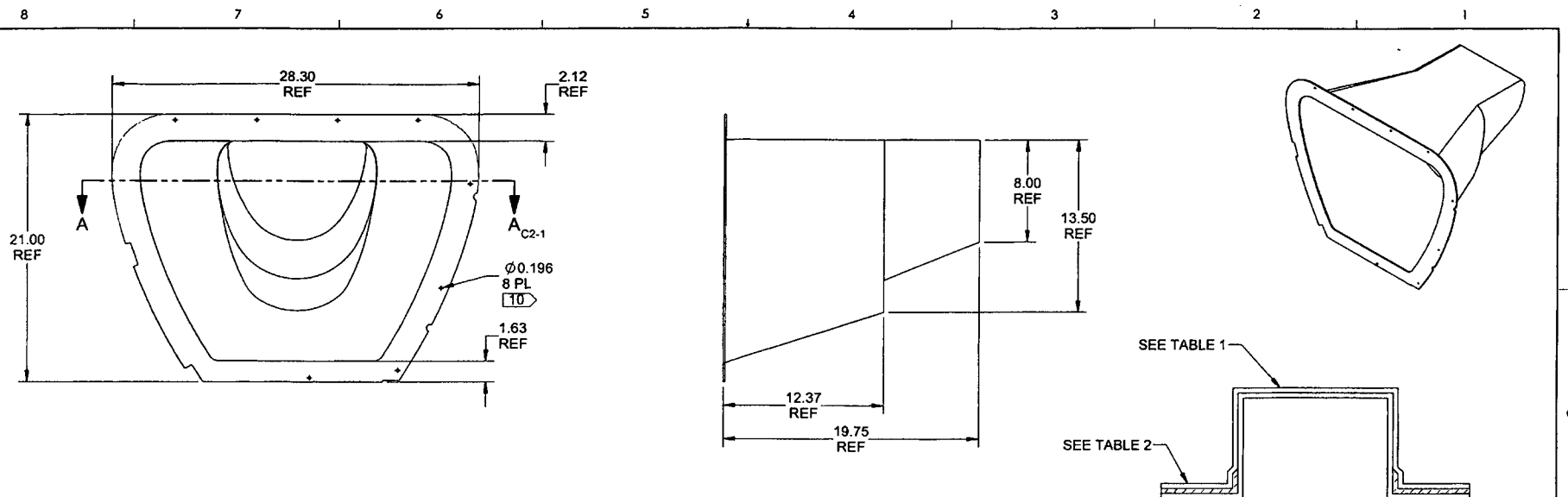
No item	Description	Qté	Qté livrée	Qté B/O
D407-605-045	REAR LOCKER EXTENDER PO item: 29950/1 Lot: B100220 B100221 B100222	3	_____	_____
D206-605-043	REAR LOCKER EXTENDER PO item: 29950/2 Lot: B100228 B100229 B100230	3 15/10/18 JP	_____	_____

Transport : _____

Nb colis : _____

Marchandise reçue : _____

Réf. : _____



D4678-1 REAR LOCKER EXTENDER

SECTION A-A

D7-1

TABLE 1

POSITION	MATERIALS
1	TOOL SURFACE
2	GEL COAT
3	7725 FIBER GLASS
4	3/4 oz CHOPPED STRAND MAT
5	7725 FIBER GLASS
6	7725 FIBER GLASS
7	PRIMER

TABLE 2

POSITION	MATERIALS
1	TOOL SURFACE
2	GEL COAT
3	7725 FIBER GLASS
4	3/4 oz CHOPPED STRAND MAT
5	7725 FIBER GLASS
6	7725 FIBER GLASS
7	7725 FIBER GLASS
8	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

TABLE 3

MATERIAL USED	DESCRIPTION
GEL COAT	4314-001 DURA FR WHITE GEL COAT
FIBER GLASS MAT	OWENS CORNING OR EQUIVALENT 3/4 oz CHOPPED STRAND MAT
FIBER GLASS CLOTH	HEXCEL 7725 FIBER GLASS
RESIN SYSTEM	PCCR 7524425UPR
PRIMER	DEFT MIL-PRF-85582E TYPE 1, CLASS 1

NOTES:

- 1) MATERIAL: SEE TABLE 3
- 2) FINISH: SEE TABLES 1, 2, & 3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 4.0 - 6.0 lbs
- 8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 9) LAYUP USING DT9869 MOLD. WET LAYUP WITH BAG/VACUUM
- 10) TRIM & DRILL PER DT9907. OPEN HOLES TO Ø0.196
- 11) CONSTRUCTION: SEE TABLES 1 & 2
- 12) MATTE TO HOLD DOWN CORNERS AS REQUIRED

A	NEW ISSUE	DC	13.04.09
REV.	DESCRIPTION	BY	DATE
DESIGN	DC		
DRAWN	DC		
CHECKED	DC		
MFG. APPR.	DC		
APPROVED	DC		
DE APPR.	DC		
DATE	13.04.09		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4678** REV. A
SHEET 1 OF 1
TITLE **206L REAR LOCKER EXTENDER** SCALE NTS

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO30202**

Purchase Order Date 10/20/2015 2:34:15 PM

PO Print Date 10/20/2015

Page Number 1 of 1

Order From :

VC-KAI001

KMLEX AVIATION INC.
5650 RUE DESSANT

SAINT-LAURENT, QUEBEC H4S 1A6
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 514-227-1693 Ext 200

Ship To Contact

Ship To Phone

Ship Via: —

Ship Acct:

Buyer

Linda Lacelle

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
2	71900-90	Flammability Testing	10/23/2015		1.00	\$90.00	\$90.00
	45 Degree Penetration Test per TP-D350-604-1, Rev.H		No 10/23/2015				
Line Total:							\$90.00
PO Total:							\$90.00

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 3

Change Date: 10/20/2015



Kmlx Aviation Inc.
5650 Dessiant, Ville St-Laurent, Quebec,
Canada, H4S 1A6
Tel: 514-227-1693, Fax: 514-227-1694

Flammability Test Results

30 SEC.-45°-FAR 25.853(h), 25.855(d), APPENDIX F PART I(a)(2)(ii),(iii)

Customer: Dart Aerospace
Item tested: Rear Locker Extender B/N 137433
Part No.: D206-605-043 Side Tested: S1
PO No.: 30202 Report No.: 35136-003

Flame Temperature (Min 1550 F): 1764 F

Results	Fill			Warp		
	EXTINGUISH TIME [SECONDS]	AFTER GLOW [SECONDS]	FLAME PENETRATION	EXTINGUISH TIME [SECONDS]	AFTER GLOW [SECONDS]	FLAME PENETRATION
1	2.30	0.00	NP		0.00	NP
2	1.70	0.00	NP			
3	0.00	0.00	NP			
4						
5						
6						
Average	1.33	0.00	NP			

Criteria: Per FAR 25.853, Appendix F Part I

Test Type	EXTINGUISH TIME [SECONDS]	AFTER GLOW [SECONDS]	FLAME PENETRATION
F5	15	10	NP



Pass



Fail

Tested by: M. Banbula

Date: 22-Oct-15

Witness by: 

Bogdan Kmiecik

• DQA:

Date: 16/02/04



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 12/01/03

Date: 16/02/03

Work Order update only ☐

Work Order: 137433	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. D206-605-013		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☒
NCR No. 16-5567		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	15.10.23	115	1	FDC COMPOSITES APPLIED PPG 694/241A 2K ACRYCOTE WHITE PAINT LOT 00022 USING CATALYST PPG 794002 2K ACRYCOTE LOT 98841 TO COVER CRACKS IN WELCOAT	A.P. 15.10.23	ACCEPTABLE, SEE COFC FROM FDC COMPOSITES INDICATING MATERIALS USED. BURN TEST PER FAR 25 APPENDIX F PART 1 (c)(2)(iii) ATTACHED AND ACCEPTED PER DE #02	A.P. 15.10.23	DAS 9 9-89 15-10-23	DAS 9 9-89 15-10-23
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☒ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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